

Work Order ID 60409

July 7, 2010 10:02:26 AM

Item ID: D3975-041

Revision ID:

Item Name: Gas Cylinder Assembly, LH

Start Date: 7/07/10 Start Qty: 4.00

Required Date: 7/08/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D3975

B

115



Packaging

Packaging

Memo

Pull from stock:

4 x 41232-002-007-001 B

re-identify as D3975-041

Apply label D3975-1

B 60430

80 10/07/09

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

~~Signature~~

8.10.07/20 (6)

130



Packaging

Packaging

Identify as per dwg & Stock Location: 105

Memo

0.00

0.00

10.7.20

GW

Work Order ID 60409

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Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

140



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp10/07/21 *[Signature]*
mf
10-7-21

Picklist Print

July 7, 2010 10:02:25 AM

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Work Order ID: 60409

Parent Item: D3975-041

Parent Item Name: Gas Cylinder Assembly, LH



Start Date: 7/07/10

Required Date: 7/08/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
10.05.27 as per ECN10-548 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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41232-200-007-001		Purchased	No				Each	9.0000		4			
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Brass Cylinder Assembly



Location

Loc Qty

Loc Code

ST365

9

39219

4

42266

4

43733

4

x2

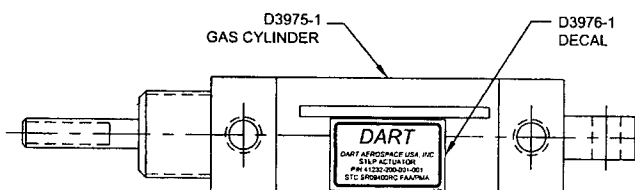
x4

11

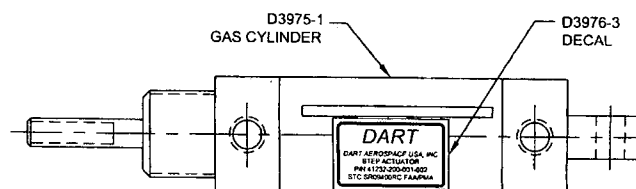
10-07-10

ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 ^B	DECAL

9x 4232.001 - 807.001



D3975-041 GAS CYLINDER ASSEMBLY



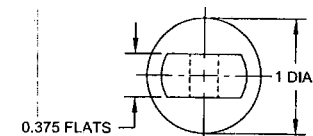
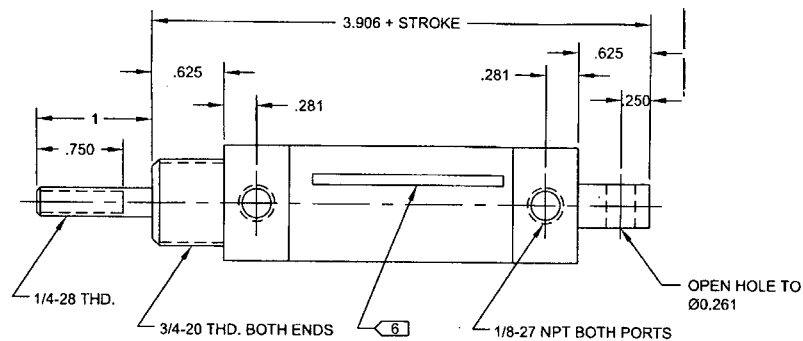
D3975-042 GAS CYLINDER ASSEMBLY

RELEASED
R 2010-05-20 D*

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1).		MB	10.04.13
A	NEW ISSUE		AJS	09.07.09
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	A			
CHECKED	P		DRAWING NO.	REV.
MFG. APPR.	D		D3975	SHEET 1 OF
APPROVED	AP		TITLE	SCALE
DE APPR.	#		GAS CYLINDER ASSEMBLY	NT
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60409 / 60410

60409



D3975-1 BRASS CYLINDER

NOTES:

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.875 INCHES
- 3) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

60409

RELEASED
R 2010-05-20

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DRAWN		PORT HADLOCK, WA	
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MFG. APPR.		D3975	SHEET 2 OF 2
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